

**Work Order ID 79807**

February-03-12 10:28:01 AM

**\*79807\***

Page 1

Item ID: D3234-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 03/02/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: M.C.J.Date: 12/02/03

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3234

C

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

2024, 050

Dwg Rev: CProg Rev: C

2-Deburr if necessary

B12-2-228

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79807

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Item ID: D3234-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 03/02/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

W 12-02-22 (8)

8 (AP/M) Feb. 22/2012

8 64 12222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 79807****\*79807\***

Page 3

February-03-12 10:28:01 AM

Item ID: D3234-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 03/02/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 177

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

2622 50 8

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

M.L.J 12/02/23112-0223 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

February-03-12 10:28:04 AM

Page 1

Work Order ID: 79807

\*79807\*

Parent Item: D3234-3

\*D3234-3\*

Parent Item Name: Doubler

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC  
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC IPP REV:C  
11.11.24 AS PER ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

68.6000

0.2165

1.367368

21

\*M2024T3S 050\*

\*\*

B12-2-22

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

68.6

117684

68.6

117684

8

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries





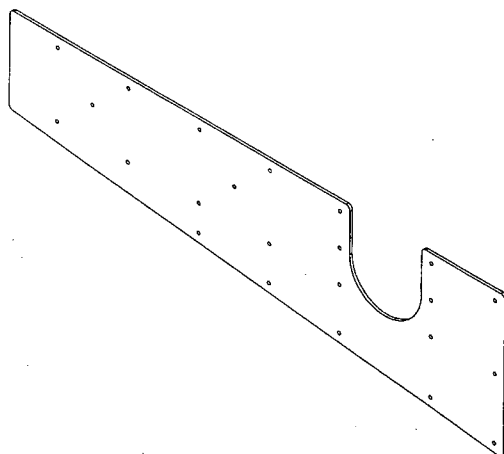
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

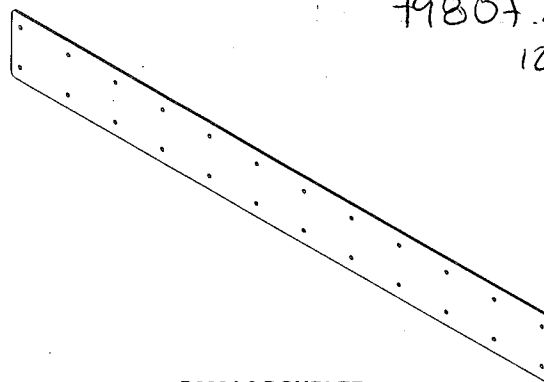
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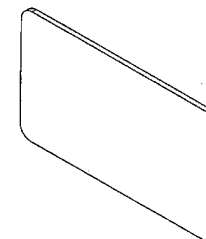
**NOTE:** Date & initial all entries



**D3234-1 DOUBLER**



**D3234-3 DOUBLER**



**D3234-5 SPACER**

79807 M.C.J  
12/02/03

**NOTES:**

1) MATERIAL: -1: 2024-T3 ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.080

-3: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1  
7) WEIGHT: -1: 0.41 lbs  
-3: 0.15 lbs  
-5: 0.01 lbs

RELEASED  
2011-11-23

C	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118.	PL	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	PL		
DRAWN	PL		
CHECKED	PL		
MFG. APPR.	PL		
APPROVED	PL		
DE APPR.	PL		
DATE	11.09.29		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3234</b> REV. C <b>DOUBLER</b> SCALE NTS <small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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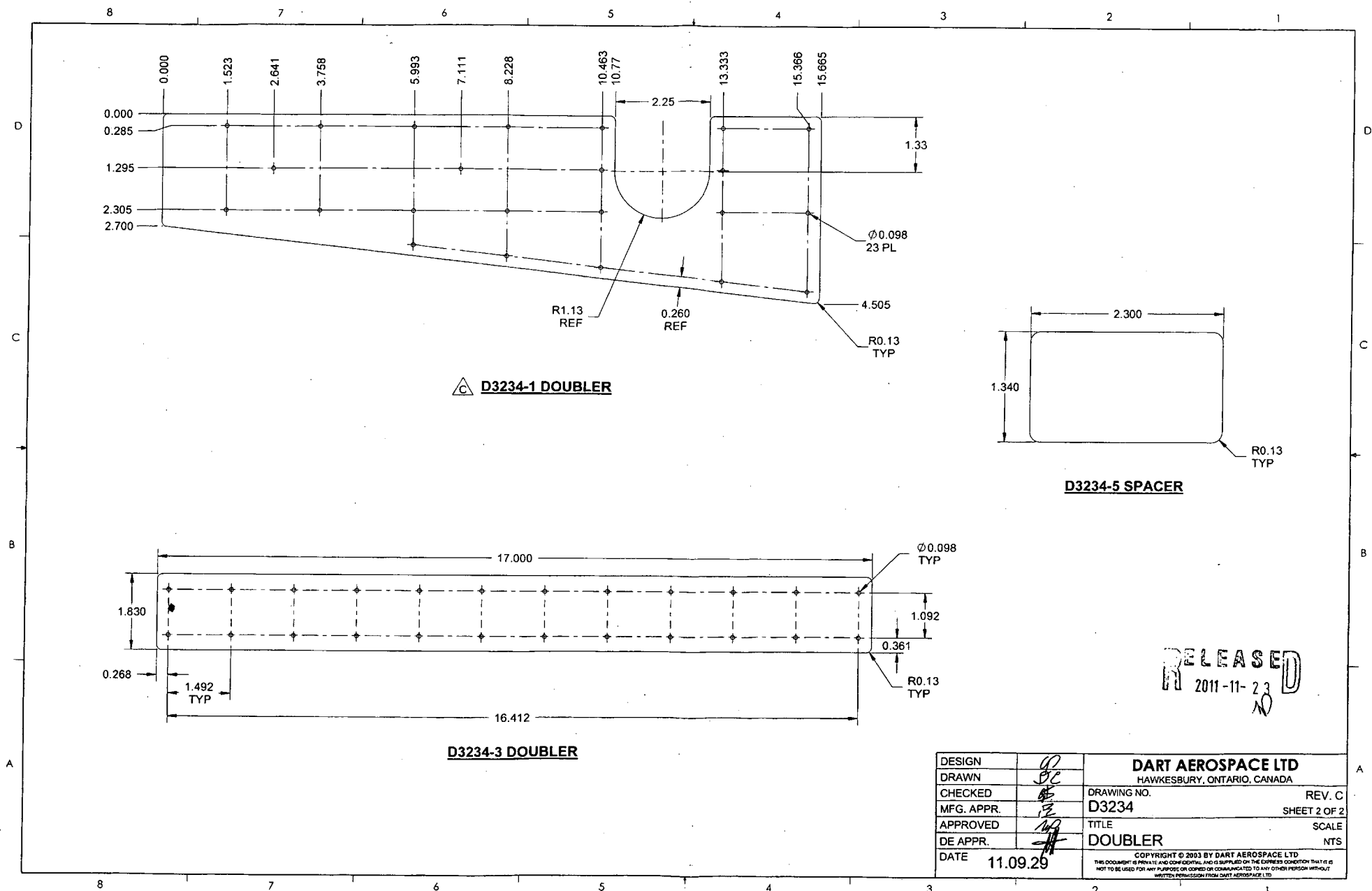
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

79807



RELEASED  
2011-11-23

DESIGN	<i>JD</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JE</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JE</i>	D3234	SHEET 2 OF 2
APPROVED	<i>JE</i>	TITLE	SCALE
DE APPR.	<i>JE</i>	DOUBLER	NTS
DATE	11.09.29	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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